














Date: Thursday, 3/20/2008 9:54:06 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 02.250 SUPPORT
Job Number	: 38122		
Estimate Number	: 11057		
P.O. Number	:	Part Number	: D28911
This Issue	: 3/20/2008 S.O. No. :	Drawing Number	: D2891 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A1
Previous Run	: 37959	Material	:
Written By	:	Due Date	: 4/3/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>08 03 20</u>		
Comment	: Est. C 02.11.26 Added P/O KJ Est D 08.03.19 Re-format EC verified: DD		

Additional Product

Job Number:			
Customer:			
Job Number:			
Seq. #	Machine Or Operation:	Description :	
Q. Number	DSK076	D2891-1 TURNING DETAIL	
This Issue			
Prsht Rev.			
First Issue			
Previous Run			
Written By	Batch: <u>08 39 210</u> 38129	<u>08/05/06</u>	Um: Each (20)
Comment:	Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s) D2891-1 TURNING DETAIL		
Q. Number	2.0 HAAS1	HAAS CNC VERTICAL MACHINING #1	
This Issue			
Prsht Rev.			
First Issue			
Previous Run			
Written By		<u>08/05/07</u>	Um: Each (20)
Comment:	HAAS Machine as per Folio FA046 Tumble & Deburr		
Q. Number	3.0 QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
This Issue			
Prsht Rev.			
First Issue			
Previous Run			
Written By		<u>08/05/07</u>	Um: Each (20)
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		
Q. Number	4.0 QC8	SECOND CHECK	
This Issue			
Prsht Rev.			
First Issue			
Previous Run			
Written By		<u>08-05-08</u>	Um: Each (20X)
Comment:	SECOND CHECK		
Q. Number	5.0 POWDER COATING	POWDER COATING	
This Issue			
Prsht Rev.			
First Issue			
Previous Run			
Written By		<u>08-05-08</u>	Um: Each (20X)
Comment:	POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		
Q. Number	6.0 QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
This Issue			
Prsht Rev.			
First Issue			
Previous Run			
Written By		<u>08/05/08</u>	Um: Each (20X)
Comment:	INSPECT POWDER COAT/CHEMICAL CONVERSION		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/20/2008 9:54:06 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 38122

Part Number: D28911

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

mf 08 05 08

20

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Job Number



mf 08 - 05 - 09

Seq. #:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38122
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.274	2.279							
B	3.702	3.722							
C	2.564	2.584							
D	0.718	0.738							
E	0.090	0.110							
F	2.464	2.484							
G	2.029	2.049							
H	2.964	2.984							
I	0.913	0.933							
J	0.022	0.042							
K	0.090	0.110							
L									
HAAS Section									
AA	0.188	0.193	DT8706	.189	.189	.189	.189		
AB	0.240	0.260		.252	.251	.251	.250		
AC	0.115	0.150		.125	.125	.125	.125		
AD	0.040	0.060		.052	.051	.051	.051		
AE	0.010	0.020		.015	.015	.015	.015		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.290	0.310		.300	.300	.300	.300		
AH	0.115	0.150		.140	.140	.138	.141		
AI	0.454	0.474		.462	.464	.464	.463		
AJ	2.779	2.789		2.784	2.784	2.784	2.784		
AK	0.240	0.260		.250	.250	.250	.250		
AL	1.002	1.042		1.037	1.037	1.040	1.036		
AM	0.053	0.073		.062	.063	.063	.063		
AN	0.257	0.262	DT8683	.258	.258	.258	.258		
AO	1.663	1.683		1.673	1.673	1.673	1.674		
AP	0.053	0.073		.063	.063	.063	.063		
AQ	0.022	0.042		.032	.032	.032	.032		
AR									
AS									
Accept/Reject									

Measured by:	J.L
Date:	08/05/05

Audited by:	S.F
Date:	08/05/10

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	J

DART AEROSPACE LTD	Work Order:	38122
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev. A1		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
Lathe Section									
A	2.274	2.279							
B	3.702	3.722							
C	2.564	2.584							
D	0.718	0.738							
E	0.090	0.110							
F	2.464	2.484							
G	2.029	2.049							
H	2.964	2.984							
I	0.913	0.933							
J	0.022	0.042							
K	0.090	0.110							
L									
HAAS Section									
AA	0.188	0.193	DT8706	190	196	189	188		
AB	0.240	0.260		248	249	251	250		
AC	0.115	0.150		126	126	126	126		
AD	0.040	0.060		052	052	051	050		
AE	0.010	0.020		015	015	015	015		
AF	0.240	0.260		250	250	250	250		
AG	0.290	0.310		303	302	304	305		
AH	0.115	0.150		140	140	139	140		
AI	0.454	0.474		463	464	463	463		
AJ	2.779	2.789		2.783	2.783	2.783	2.783		
AK	0.240	0.260		246	240	240	240		
AL	1.002	1.042		1.038	1.038	1.039	1.038		
AM	0.053	0.073		063	063	063	063		
AN	0.257	0.262	DT8683	258	258	258	258		
AO	1.663	1.683		1.676	1.673	1.675	1.675		
AP	0.053	0.073		063	063	063	063		
AQ	0.022	0.042		032	032	032	032		
AR									
AS									
Accept/Reject									

Measured by:	<i>mf</i>
Date:	08/05/10

Audited by:	<i>SP</i>
Date:	08/05/10

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 38122
Description: Ø2.250 Support	Part Number: D2891-1
Inspection Dwg: D2891 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2891 Rev.A1/DSK076 Rev.A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 9	1 10	3	4	By	Date
Lathe Section									
A	2.274	2.279							
B	3.702	3.722							
C	2.564	2.584							
D	0.718	0.738							
E	0.090	0.110							
F	2.464	2.484							
G	2.029	2.049							
H	2.964	2.984							
I	0.913	0.933							
J	0.022	0.042							
K	0.090	0.110							
L									
HAAS Section									
AA	0.188	0.193	DT8706	.189	.188				
AB	0.240	0.260		.250	.251				
AC	0.115	0.150		.125	.126				
AD	0.040	0.060		.048	.049				
AE	0.010	0.020		.015	.015				
AF	0.240	0.260		.250	.250				
AG	0.290	0.310		.300	.300				
AH	0.115	0.150		.140	.140				
AI	0.454	0.474		.463	.463				
AJ	2.779	2.789		2.783	2.783				
AK	0.240	0.260		.250	.250				
AL	1.002	1.042		1.040	1.040				
AM	0.053	0.073		.063	.063				
AN	0.257	0.262	DT8683	.259	.259				
AO	1.663	1.683		1.676	1.672				
AP	0.053	0.073		.063	.063				
AQ	0.022	0.042		.032	.032				
AR									
AS									
Accept/Reject									

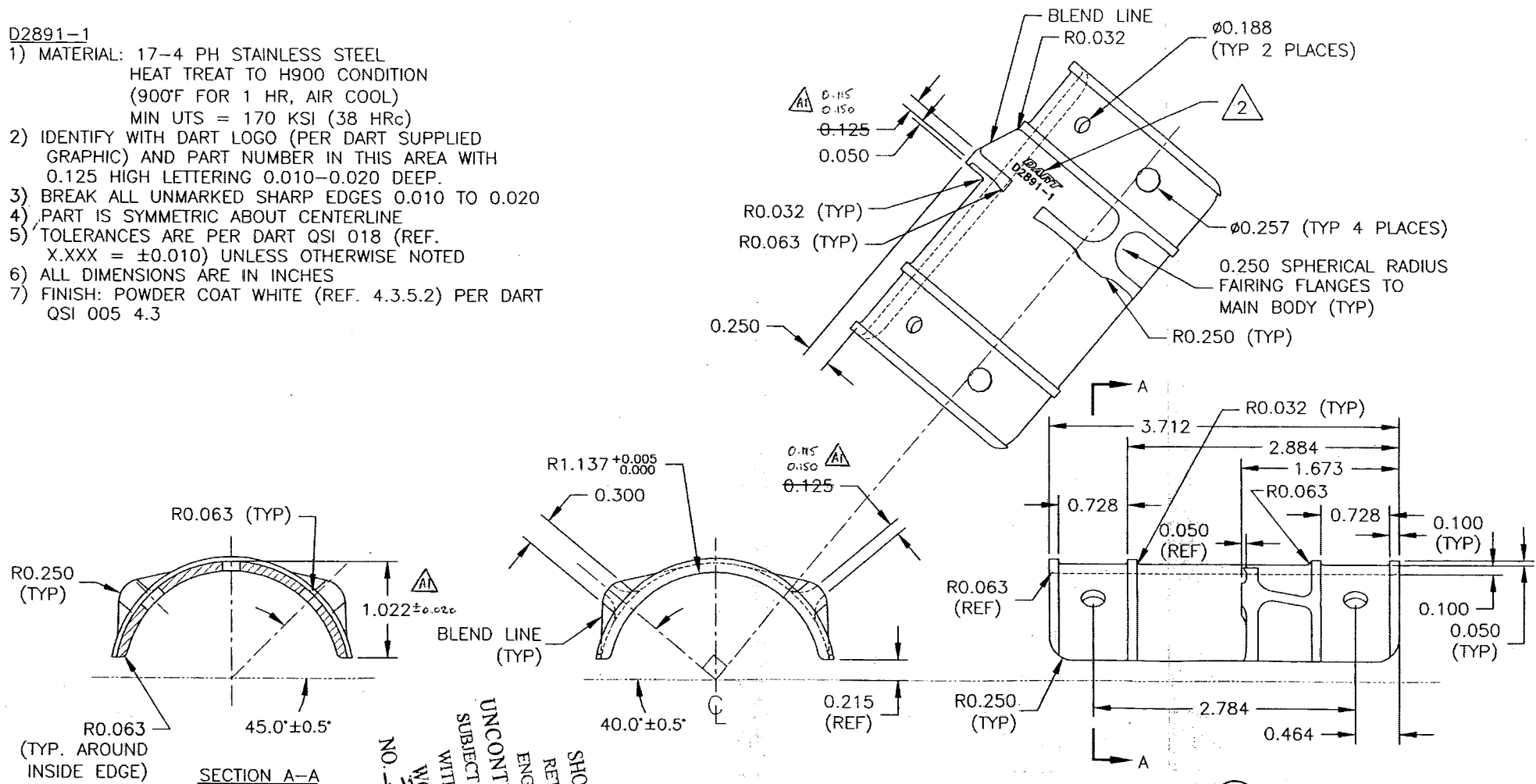
Measured by:	<i>ML</i>
Date:	08/05/07

Audited by:	<i>JP</i>
Date:	08/05/10

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF <i>+</i>	<i>+</i>

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



NO. 38122
WORK ORDER
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ENGINEERING
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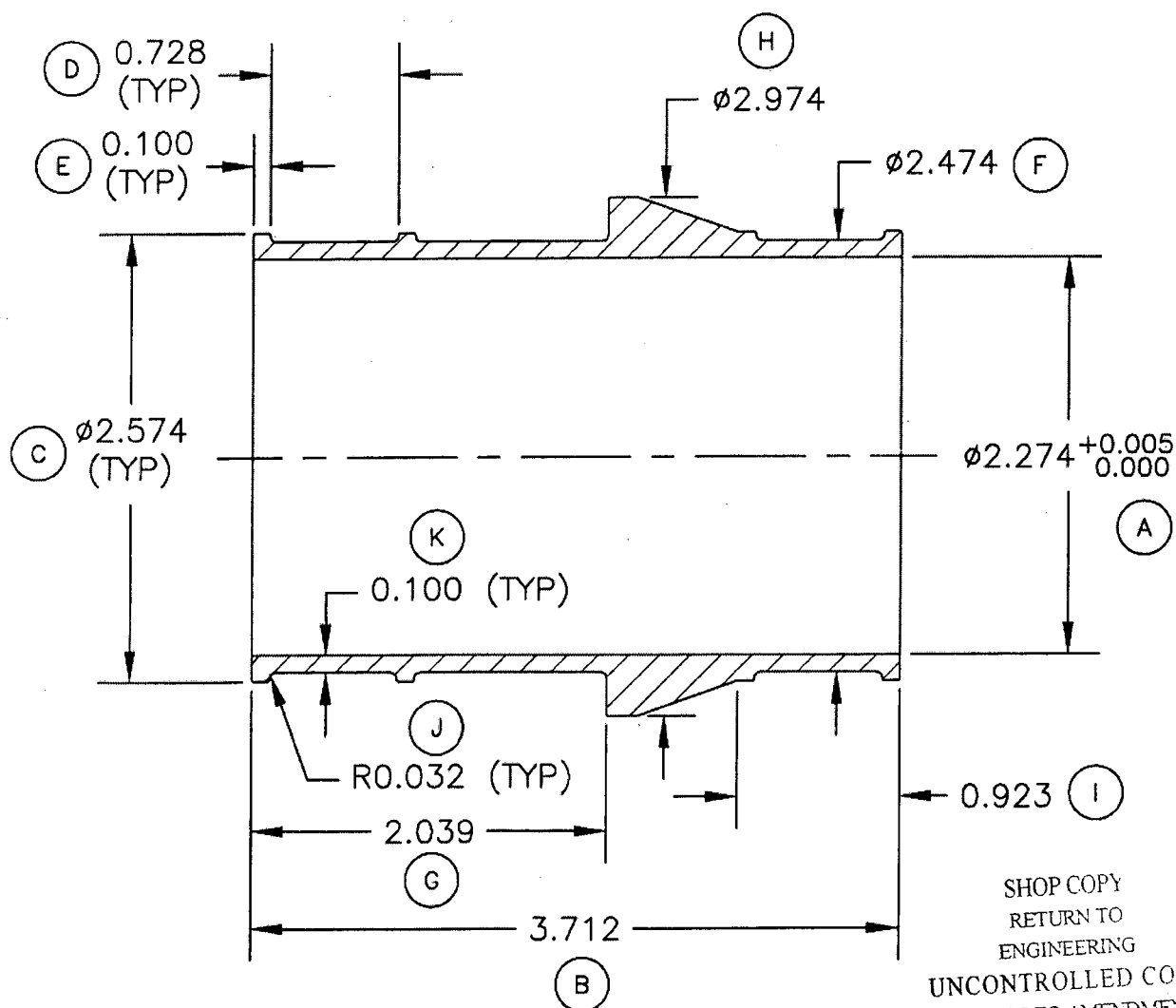
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AI	#CP 02.01.23	UPDATE DIMS AS MANUFACTURED
A	00.11.17	NEW ISSUE
DESIGN	CP	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2891
DATE	00.11.17	TITLE Ø2.250 SUPPORT
		REV. A SHEET 1 OF 1 SCALE 1:1

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01 [Signature]

D2891-1 TURNING DETAIL

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